

016751



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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Tel (613) 632-5200
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D3294-1

Job Sheet 201113



Part No: D3294-1

Job Qty: 12 pcs

DAS
21
9-59

Part Name: Bracket For Interior Window For -115



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/25/19

Job Tracking No:

Due Date: 10/24/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV D IPP A 04.08.24 New issue KJ/JLM IPP Rev:B Now On Waterjet 07-03-26 JLM IPP Rev:C 08-07-16 Redesign part DD verified by:EC IPP Rev:D 08-10-06 revB as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		10/11/19	0.17	3.85	Waterjet - Flow		on 20/02/13 TF
110	QC 2	12 pcs		10/11/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		on 20/02/13 TF
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		

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				QC 2 - 62					
				QC 2 - 63					
				QC 2 - 8					
				QC 2 - 66					
				QC 2 - 64					
				QC 2 - 65					
				QC 2 - 5					
				QC 2 - 71					
				QC 2 - 73					
				QC 2 - 69					
120 QC 8	12 pcs	10/11/19	0.00 0.00	QC 8 - 12					
				QC 8 - 14					
				QC 8 - 17					
				QC 8 - 20					
				QC 8 - 25					
				QC 8 - 3					
				QC 8 - 32					
				QC 8 - 33					
				QC 8 - 35					
				QC 8 - 39					
				QC 8 - 4					
				QC 8 - 44					
				QC 8 - 45					
				QC 8 - 49					
				QC 8 - 58					
				QC 8 - 8					
				QC 8 - 9					
				QC 8 - 68					
				QC 8 - 67					
				QC 8 - 1 (A)					
				QC 8 - 47					
				QC 8 - 40					
				QC 8 - 52					
				QC 8 - 23					
				QC 8 - 57					
				QC 8 - 76					
				QC 8 - 61					
				130 Small Fab - Brake NC - B4B	12 pcs	10/11/19	0.25 1.66	Small Fab - Brake - 1 - B4B	DAS FEB 1 4 2020 40 9-89
								Small Fab - Brake - 2 - B4B	
								Small Fab - Brake - 3 - B4B	
140 QC 5	12 pcs	10/11/19	0.00 0.00	QC 5 - 10					
				QC 5 - 12					
				QC 5 - 17					
				QC 5 - 18					
				QC 5 - 19					
				QC 5 - 22					
				QC 5 - 24					
				QC 5 - 3					
				QC 5 - 43					
				QC 5 - 49					
				QC 5 - 51					
				QC 5 - 58					
				Plex 9/25/19 10:40 AM Dart.Renwick.Jennifer					

					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	DAS FEB 27 2020 40 9-89
					QC 5 - 61	
					QC 5 - 81	
					Handfinish - 1 - 1 - B4B	
150 Handfinish - 1-1 Chemical- B4B	12 pcs	10/11/19	0.00 0.92		Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
160 QC 7	12 pcs	10/11/19	0.00 0.00		QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	DAS 30 FEB 28 2020 9-89
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	

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				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
170 Small Fab - 2 - B4B	12 pcs	10/11/19	0.00 1.88	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	MAR 02 2020
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
180 QC 5	12 pcs	10/11/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	MAR 02 2020
				QC 5 - 61	
				QC 5 - 81	
190 Powdercoat - 4 Black Sand - B4B	12 pcs	10/11/19	0.00 0.53	Powdercoat - 1 - B4B	BEB 20-03-02
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
200 QC 3	12 pcs	10/11/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	

				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	DAS
				QC 3 - 40	MAR 02 2020 40
				QC 3 - 19	9-89
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
210 Packaging 3-1 - Stock - B4B	12 pcs	10/11/19	0.00 0.00	Packaging 3 - 1 - B4B	
	7 pcs			Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	28
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	12 pcs	10/11/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
					9-89
					MAR 03 2020

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QC 21 - SA - 53

Part Op **100** - 1-Cut as per Dwg D3294 CUt File D3294-3 Dwg Rev: D Prog Rev: D *grain direction on a 45 deg as
 Descriptions: per dwg** 2-Deburr if necessary

110 - (QC2- Inspect parts off machine FAI/FAIB)**120** - (QC8- Inspect parts - second check)**130** - 1-Deburr if necessary 2-Bend as per Dwg D3294 (Ensure angle is correct)**140** - (QC5- Inspect part completeness to step on W/O)**150** - (Chemical Conversion Coat per QSI005 4.1)**160** - (QC7-Inspect Chemical Conversion Coat)**170** - 1-Install D3294-5 doubler to D3294-3 bracket with rivets as per dwg. D3294**180** - QC5- Inspect part completeness to step on W/O)**190** - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) Start Time: 1:40 Oven Temperature: 320° FinishS156440 Time: 1:40**200** - (QC3- Inspect Part Finish)**210** - (Identify as per dwg & Stock Location: _____)**220** - (QC21- Final Inspection - Work Order Release)**Job BOM**

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.080	2024-T3 .080 Sheet	21.6000 sf (1.8 ea)	100-Waterjet - Flow - 1	S216343
D3294-5	Doubler	7 12 pcs (1 ea)	170-Small Fab - 2 - B4B	S194286
MS20470AD4-5	Rivet, Universal Head	105 180 Ea (15 ea)	170-Small Fab - 2 - B4B	S198109

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.080	22	177	0
170-Small Fab - 2 - B4B	D3294-5	12	20	0
	MS20470AD4-5	180	1,992	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order: 8201113
Description: Bracket Assembly		Part Number: D3294-1
Inspection Dwg: D3294 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.129	/		Tape	
Ø0.141	+0.005/-0.001	0.141	/		Caliper	
6.708	+/-0.010	6.716	/			
1.118	+/-0.010	1.125	/			
5.590	+/-0.010	5.597	/			
1.118	+/-0.010	1.121	/			
13.563	+/-0.010	13.563	/			
1.043	+/-0.010	1.043	/			
0.625	+/-0.010	0.624	/			
0.325	+/-0.010	0.328	/			
0.300	+/-0.010	0.306	/			
0.400	+/-0.010	0.403	/			
6.000	+/-0.010	6.001	/			
1.000	+/-0.010	1.001	/			
17.124	+/-0.010	17.124	/			
16.13	+/-0.030	16.13	/			
7.27	+/-0.030	7.275	/			
11.97	+/-0.030	11.97	/			
8.37	+/-0.030	8.37	/			
20.05	+/-0.030	20.05	/			
12.98	+/-0.030	12.98	/			
14.59	+/-0.030	14.59	/			
11.66	+/-0.030	11.66	/			
0.080	+/-0.010	0.081	/			

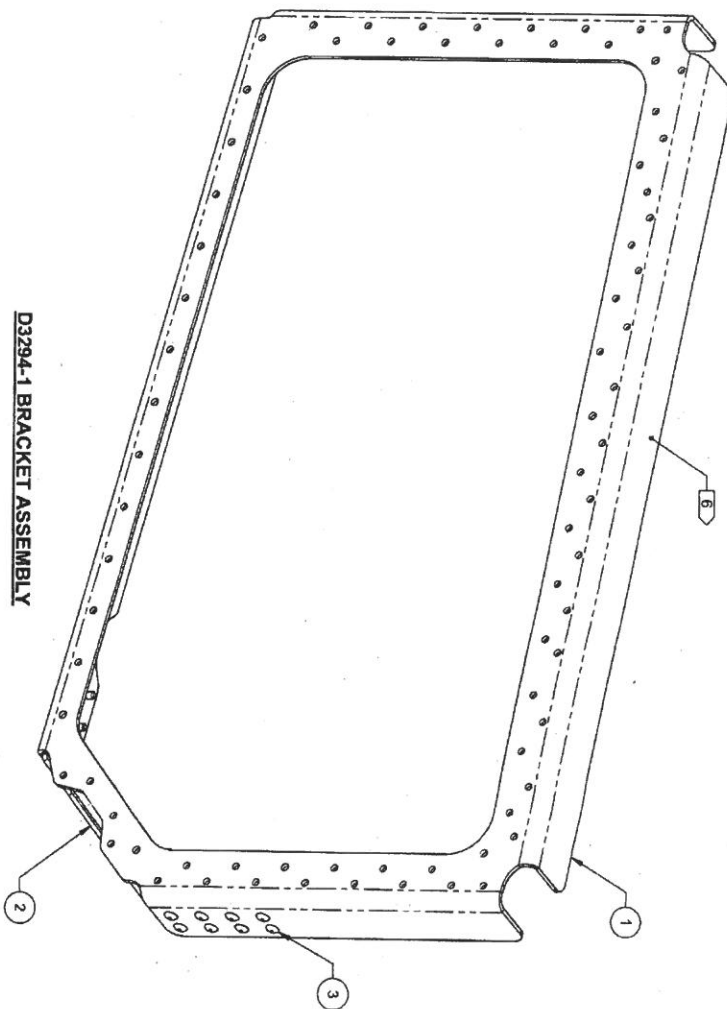
Measured by: TF / or	Audited by: DAS 40 9-89	Preliminary Approval:
Date: 20/02/13	Date: FEB 14 2020	Date:

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	
C	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ	
F	13.05.08	Dwg Rev updated	KJ	

ITEM	QTY	P/N	DESCRIPTION
1	X	D3294-1	BRACKET ASSEMBLY
2	1	D3294-3	BRACKET
3	1	D3294-5	DOUBLER
4	15	MS20470AD4-5	RIVET

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 20113

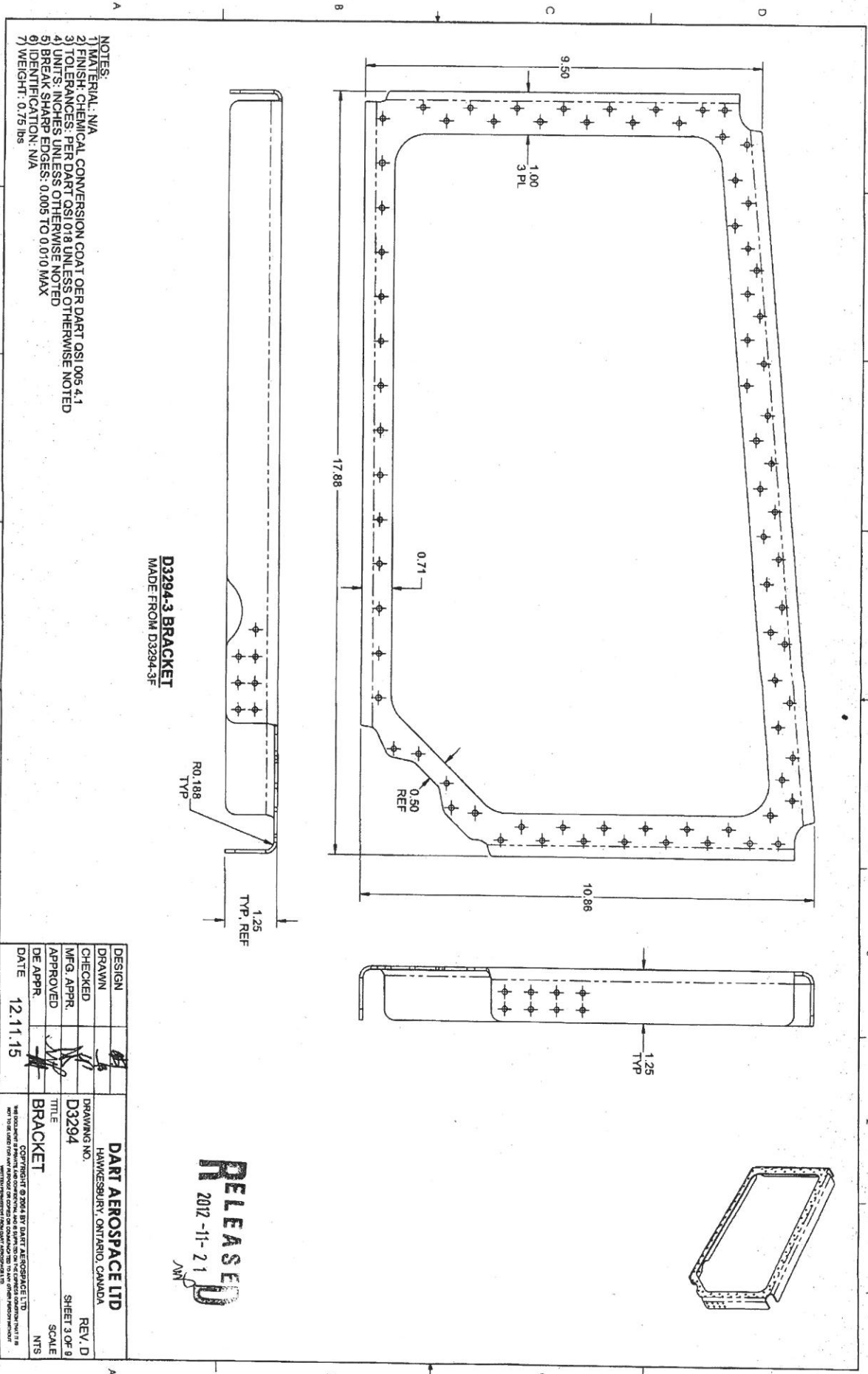
D3294-1 BRACKET ASSEMBLY



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART OSI 005 4.3
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1" PER DART OSI 044 6.1
 - 7) WEIGHT: 0.83 lbs

REV.	DESCRIPTION	DATE
D	ADD D3294-1B, 3B, 5B, 7B, REASON: PART 2-23	12.11.15
C	REMOVE FLANGE PREVIOUSLY ADDED. ADD 5	09.03.24
B	DOUBLER ZN AL-1, SHEET 5/8	
A	CHANGE FLANGE FROM OUTSIDE TO INSIDE. ZN B4-1, CS	08.09.22
	2. CHANGE GRAIN DIRECTION. ZN C42	04.08.28
	NEW ISSUE	
DESIGN	DART AEROSPACE LTD	
DRAWN	HAWKESBURY, ONTARIO, CANADA	
CHECKED	D3294	REV. D
MFG. APPR.		SHEET 1 OF 9
APPROVED		SCALE
DE APPR.		NTS
DATE	12.11.15	

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2012-11-21



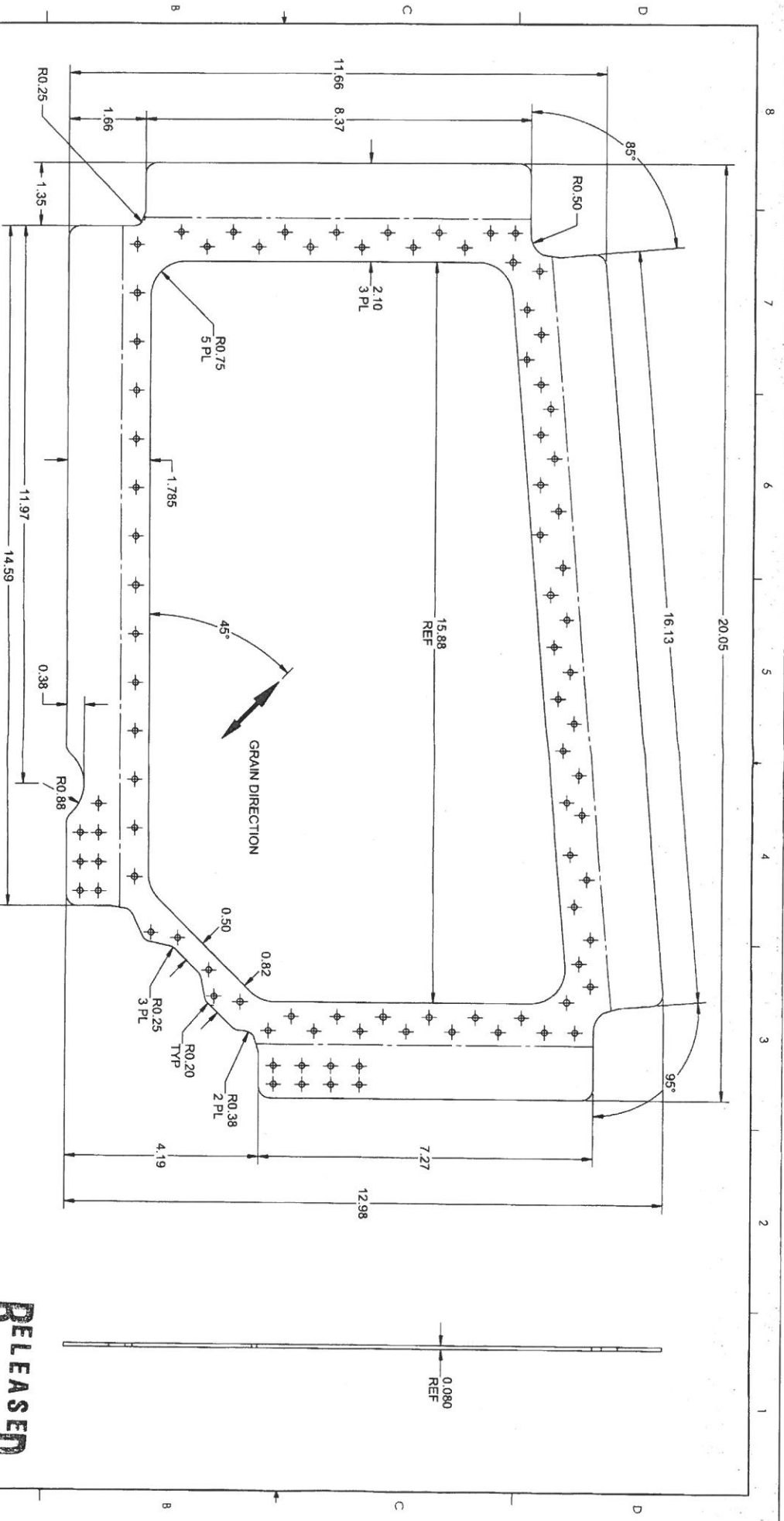
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT QER DART OSI 1005 4:1
 - 3) TOLERANCES: PER DART OSI 1018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.75 lbs

D3294-3 BRACKET
MADE FROM D3294-3F

DESIGN	DE1	DART AEROSPACE LTD
DRAWN	JB	HAWKESBURY, ONTARIO, CANADA
CHECKED	W	DRAWING NO. D3294
MFG. APPR.	W	REV. D
APPROVED	W	SHEET 3 OF 8
DE APPR.	W	SCALE NTS
DATE	12.11.15	TITLE BRACKET

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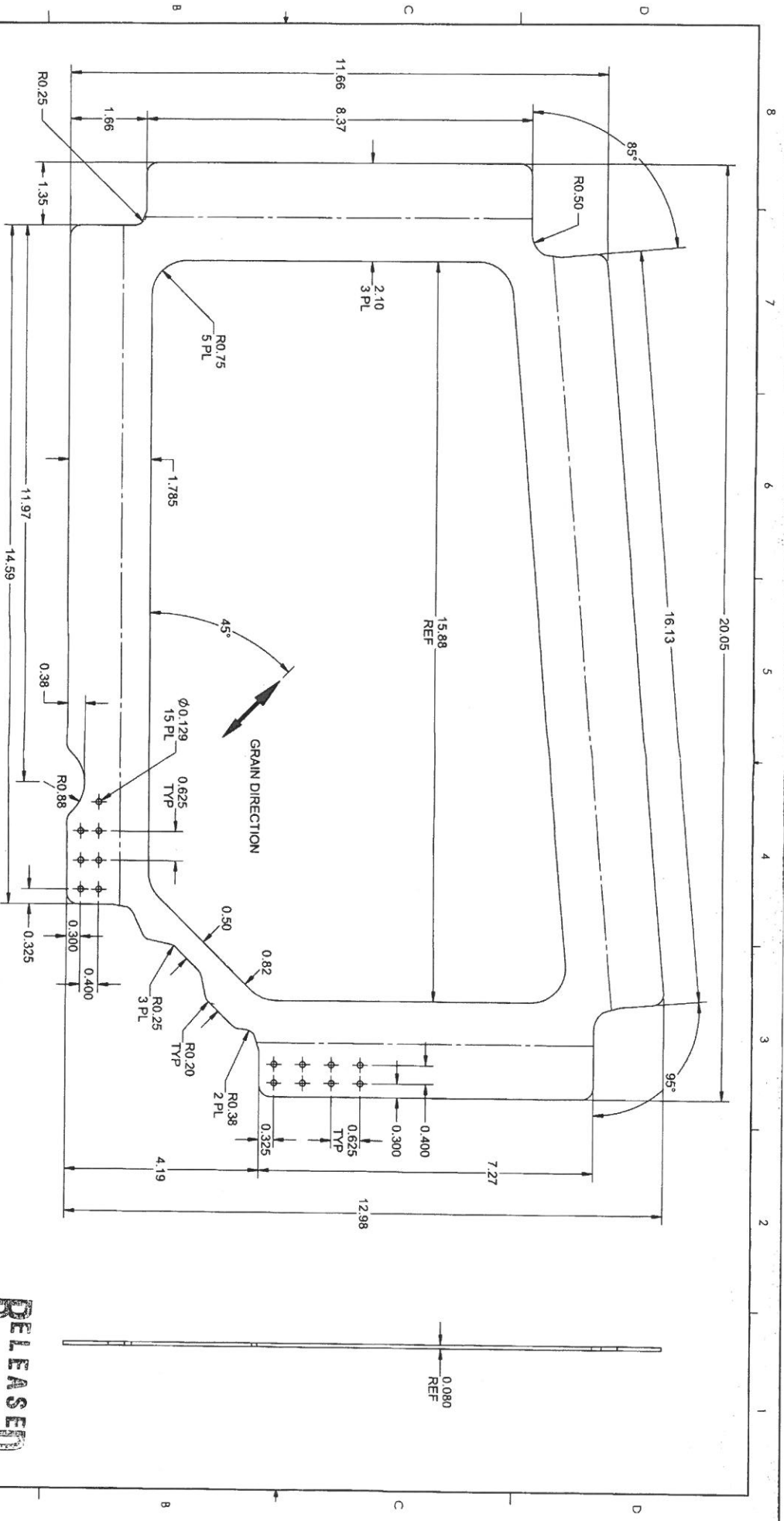
- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024135.080)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.75 LBS

D3294-3F BRACKET FLAT PATTERN

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	12.11.15	
TITLE	BRACKET	
REV.	D	
SHEET	1 OF 9	
SCALE	NTS	

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D3294-3BF BRACKET FLAT PATTERN, BLANK

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.080)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.75 lbs

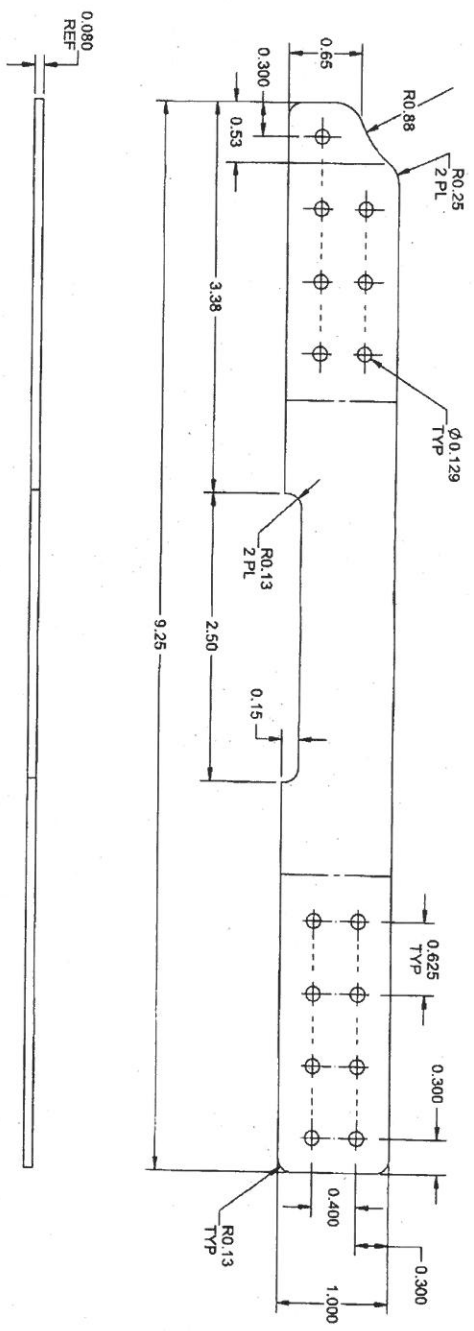
DESIGN		DART AEROSPACE LTD
DRAWN		HANKESSBURY, ONTARIO, CANADA
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	12.11.15	
TITLE	BRACKET	
SCALE	NTS	

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- NOTES:
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 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.07 lbs

D3294-SF DOUBLER FLAT-PATTERN



DESIGN	DART AEROSPACE LTD
DRAWN	HAWKESBURY, ONTARIO, CANADA
CHECKED	D3294
MFG. APPR.	REV. D
APPROVED	SHEET 9 OF 9
DE APPR.	SCALE
DATE 12.11.15	NTS
	BRACKET

RELEASE
2012-11-21

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

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